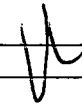



Date: Tuesday, 29/04/2008 10:54:48 AM  
 User: Linda Lacelle

## Process Sheet

OK

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: TUBE
Job Number	: 38885		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D37703
This Issue	: 29/04/2008 S.O. No. :	Drawing Number	: PROTOTYPE
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : R & D SM/MED FAB	Drawing Revision	:
Previous Run	: 38883	Material	:
Written By	: 	Due Date	: 16/05/2008 Qty: 4 Um: Each
Checked & Approved By	: 		
Comment	:		

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

MAKE PER DRWG D3770 REV A

#107950

FF 08-05-12

2.0	M6061T6T1000W065	6061T6 TUBE
-----	------------------	-------------



Comment: Qty.: 1.9000 f(s)/Unit Total: 7.6000 f(s)  
 6061T6 TUBE

#107950

FF 08-05-08

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING  
APPROVAL

08/05/12 (4) / 08.05.14

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

ACID ETCH AND ALODINE PER QSI 005

RD/m 08/05/14

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.05.14 (4)

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: TUBE

Job Number: 38885

Part Number: D37703

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

GIVE TO CHRIS P-ENG

CHARGE TO JOB #00196

**FOR ENGINEERING USE ONLY**

*PH*  
*08.05.29*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

**CERTIFICATE OF CONFORMITY  
REQUIRED**

*08.05.29 Prototype*

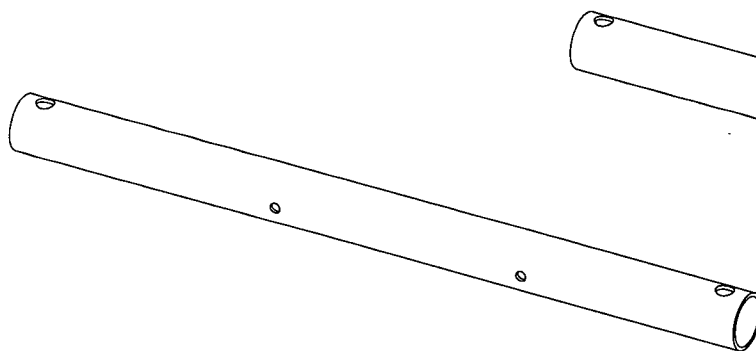
Job Completion



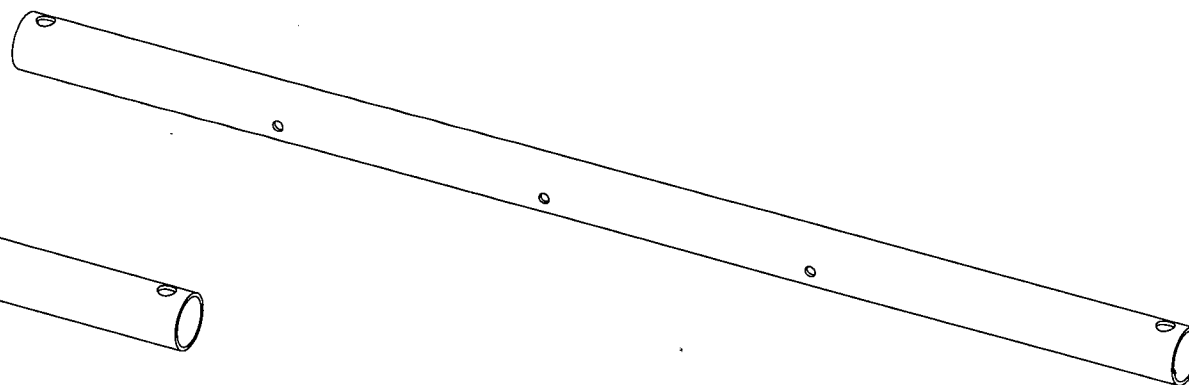
*u 08-06-11*

**PROTOTYPE**  
**PLEASE RETURN ALL ISSUED**  
**DATA TO ENGINEERING**

08.04.23



**D3770-1 TUBE**



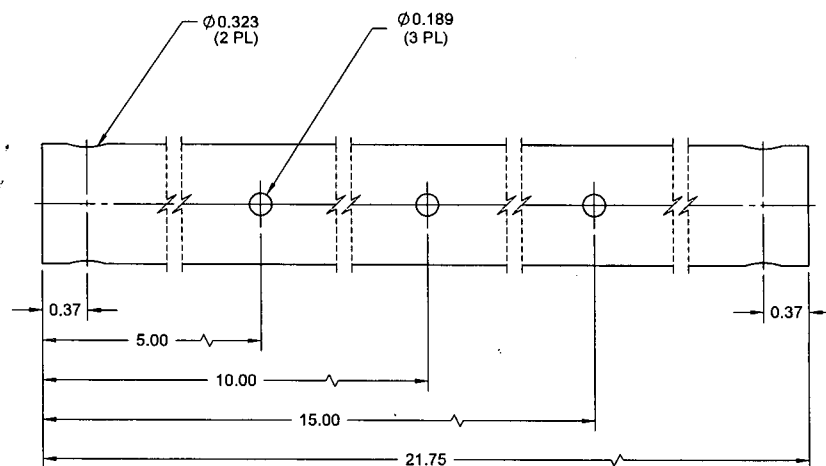
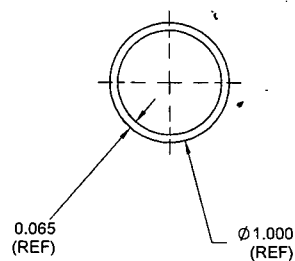
**D3770-3 TUBE**

**NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM TUBING 1.00" X 0.065" WALL (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3770-1, 0.25 lbs  
D3770-3, 0.40 lbs

REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3770	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		TUBE	NTS
DATE	08.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**PROTOTYPE**  
 PLEASE RETURN ALL ISSUED  
 DATA TO ENGINEERING  
 08.04.23



**D3770-3 TUBE**

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3770</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>TUBE</b>	1:1
DATE	<b>08.03.26</b>	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

# Receiving Report

Date: 8/0/6  
 Supplier: MARNON

Batch No: M107950  
 Dart P/O: 6269

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☒ No ☐ N/A ☐  
 Shipment Complete: Yes ☒ No ☒ N/A ☐  
 QC6 Inspection ☒ Good N/A ☐  
 Work Order ☐ N/A ☒

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 CU

Production/Admin: 08/05/08  
 Date R/R 7822  
 Received/Costing CR  
 Initial CR

Location \_\_\_\_\_

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

RECEIVED MAY 09 2008

Energy Surcharge

12.20

ORIGINAL INVOICE / FACTURE ORIGINALE

G.S.T. /HST T.P.S.	18.02
PROVINCIAL TAX TAXE PROVINCIALE	.00

TERMS: NET 30 DAYS  
 1.5% CN PER MONTH ON  
 OVERDUE ACCOUNTS.

TERMES: NET 30 JOURS  
 PLUS 2% PAR MOIS  
 SUR COMPTE PASSE DÙ.

FOR CONDITIONS OF SALE REFER TO BACK OF INVOICE.  
 POUR LES CONDITIONS DE VENTE, VOUS TROUVEREZ LES  
 RENSEIGNEMENTS À L'ENDOS DE LA FACTURE ORIGINALE.

PAYMENT OF THIS INVOICE IS DUE BY  
 LE RÈGLEMENT DE CETTE FACTURE EST EXIGIBLE AU PLUS TARD LE

06/04/2008

378.38

FEB 18 2008 15:44 FR MARMON KEYSTONE

6309722464 TO 14506414357

P.02/03

02/18/2008 From: MARMON/KEYSTONE  
M/K OR:  
C.P.O.:  
C PART:

INIT.:

To:

OR. REF:  
SLSPRS:

# KAISER ALUMINUM FABRICATED PRODUCTS

KAISER ALUMINUM  
FABRICATED PRODUCTS  
6573 W. WILLIS ROAD  
CHANDLER, AZ 85226

## CERTIFIED TEST REPORT

<http://www.KaiserAluminum.com>

CUSTOMER PO NUMBER: 80-33603		CUSTOMER PART NUMBER: AT/1.065/734		PRODUCT DESCRIPTION: Seamless Tube	
KAISER ORDER NUMBER: 200438	LINE ITEM: 005	SHIP DATE: 11/27/2007	KAISER LOT NUMBER: F00000606	ALLOY: 6061	TEMPER: T6
WEIGHT SHIPPED: 331.000 LB	QUANTITY: 123.000 PCS	BL NUMBER: 200274	DIA/DIA THICKS: 12.000 FT	WEIGHT:	LENGTH:
SHIP TO: MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA			SOLD TO: MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA		

### Actual Physical Properties

REFERENCE	DASH	SAMPLES	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CONTRAST	REMARKS
F00000606	0001	1	46.5	42.6	17.0	N/A	N/A	N/A

### Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Sr	Ca	Tot
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
R22453	.62	.39	.22	.05	.92	.06	.03	.03	.00	.01	.00	.00	.00

### CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms conditions of sale. Test reports are on file subject to examination.

Wilfredo A. de la Cruz, Sr. Metallurgical Engineer

Plant Serial: 00000264

*Wilfredo A. de la Cruz*

Page 1 of 2

Kaiser Order Number: 200438

Line Item: 005

**Q.C. REVIEWED**

FEB 05 2008 13:10

AT 1.065 734

PAGE 02

18 2008 15:44 FR MARMON KEYSTONE

6308722464 TO 14564157

2/2008 From: MARMON/KEYSTONE  
OR:  
C.P.O.:  
C PART:

INIT.:

To:

OR. REF:  
SLSPRS:

# KAISER ALUMINUM

FABRICATED PRODUCTS

KAISER ALUMINUM  
FABRICATED PRODUCTS  
6573 W. WILLIS ROAD  
CHANDLER, AZ 85226

CERTIFIED TEST REPORT  
<http://www.KaiserAluminum.com>

## Applicable Requirements:

Description: OD: 1.000"; Wall: 0.065"; Round @  
AMS-1082N ASTM-B210-04 WW-T-700/6F  
WE TAKE EXCEPTION TO PARA. 5.2.1. Per AMS 1082N, WAS NOT OILED.  
THE FOLLOWING SPECIFICATION HAVE BEEN MADE INACTIVE OR  
CANCELLED: MIL-T-7081, WW-T-700F/GEN, WW-T-700/2E, WW-T-700/3F.  
WW-T-700/4F, WW-T-700/5E, WW-T-700/6F, WW-T-700/7E.  
COMPLIES TO THE REQUIREMENTS OF DIN EN 10204  
COMPLIES TO DIN EN 10204 JAN 2005

## Miscellaneous Notes

MANUFACTURED IN USA MELTED IN USA

## CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms conditions of sale. Test reports are on file subject to examination.

Wilfredo A. de la Cruz, Sr. Metallurgical Engineer

*Wilfredo A. de la Cruz*

Page 2 of 2

Plant Serial: 00000264  
Kaiser Order Number: 200438  
Line Item: 005

PAGE.03

FEB 06 2008 13:11

\*\* TOTAL PAGE.03 \*\*

Date: Thursday, 29/05/2008 1:15:31 PM

User: Linda Lacelle

**JOB HISTORY : DETAIL**

<b>Job Number</b>	: 38885	<b>Customer</b>	: Dart Aerospace Ltd.
<b>Estimate Number</b>	: 10804	<b>DWG Name</b>	: TUBE
<b>Purchase Order #</b>	:	<b>Part Number</b>	: D37703
<b>Complete Date</b>	: / / : : AM	<b>DWG Number</b>	: PROTOTYPE
		<b>Rev.</b>	:

<b>DUE DATE</b>	<b>ORDERED</b>	<b>DELIVERED</b>
16/05/2008	4	0

**1.0 SMALL FAB 1 Internal Operation**

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
08/05/2008	FRAN01: Franken, Frans	Run	4.000	2.04	\$34.37	2.04	90.74
12/05/2008	FRAN01: Franken, Frans	Run	4.000	1.70	\$28.65	1.70	75.64

**Subtotal:** QTD: 8 CTD: 0 3.74 \$229.40

**2.0 M6061T6T1000W065-6061T6 TUBE INVENTORY ITEM**

DATE	EMPLOYEE	TYPE	Qty	COST	Lot # 107950 Qty. 8
08/05/2008	FRAN01: Franken, Frans	M6061T6T1000W065	7.600	\$17.84	

**Subtotal:** QTD: 0 CTD: 8 \$17.84

**4.0 HAND FINISHING1 Internal Operation**

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
14/05/2008	GREG01: Gregory, Marc	Run	4.000	0.11	\$1.71	0.32	14.89

**Subtotal:** QTD: 4 CTD: 0 0.11 \$16.60

		TIME	COST
	Machine Time:	4.06	\$181.27
	Labor:	3.85	\$64.73
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$17.84
	SUB-COMPONENT (SUB-JOB):		\$0.00
<b>Total:</b>			\$263.84

COST PER UNIT: \$263.84